

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004010**Date Inspected:** 02-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Yang / An Qing Xiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** tower stiffener to skin plate assemblies**Summary of Items Observed:**

Tower shop - Bay 1

QA Inspector randomly observed approximately 65 ZPMC workers performing the following: FCAW-G of stiffener C6 to SSD1 – skin C, weld joints SSD1-SA179C/E-18 & 17; FCAW-G of stiffener to SSD1 – skin A while tilted up to form a flat welding position; flame cutting bevels on stiffeners; preheating and FCAW-G tacking of stiffeners to SSD1 – skin D; FCAW-G, manual and automatic using gantry, of stiffeners to SSD1 – skin B. Also present in this bay and monitoring the above noted welding were ZPMC CWI Liu Yang, and ABF QC Zhang Qin Jian. Items observed appeared to comply with project specifications.

Tower shop - Bay 2

QA Inspector randomly observed approximately 60 ZPMC workers performing the following: grinding of root pass on ESD1 – skin D; preheating and FCAW-G tacking of stiffeners to ESD1 – skin C; FCAW-G of stiffener to ESD1 – skin A while tilted up to form a flat welding position; FCAW-G, manual and automatic using gantry, of stiffeners to ESD1 – skin B; heat straightening of skin plate; flame cutting of bevels on stiffener plates; SMAW of run-off tabs to skin plate in preparation of SAW at ESD1-SA300A/F-3A and ESD1-SA300A/F-4A. Also present in this bay were ZPMC CWI An Qing Xiang and ABF QC Wang Cheng Jun. Items observed appeared to comply with project specifications.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

No significant conversations this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, 136-6471-0411, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
